

Date: Thursday, 02/04/2009 2:22:05 PM
User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR ARM
Job Number	: 46818	Part Number	: D2010103
Estimate Number	: 10505	Drawing Number	: D2010 REV'D
P.O. Number	:	Project Number	: N/A
This Issue	: 02/04/2009	Type	: SMALL /MED FAB
Prsht Rev.	: NC	Drawing Revision	: D
First Issue	: / /	Material	:
Previous Run	: 45811	Due Date	: 14/04/2009
Written By	:	Qty:	10
Checked & Approved By	: <u>JUL 09.04.02</u>	Um:	Each
Comment	Est : F 02.08.21 Re-format; Added D2057 Est Rev:G 08-05-27 as per ECN1195P DD verified by:EC Est Rev:H 08-06-20 rev.D as per dwg DD verified by:EC	KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W049	304 RD Tube .500 x .049W	<u>M110968 7X</u> *
			<u>M1108823 3X</u> <u>m-f 09/04/23</u>
2.0	BRAKE NC	NC BRAKE	<u>m-f 09/04/23</u> <u>10X</u>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	<u>m-f 09/04/23</u> <u>10X</u>
4.0	D2057	Plug	<u>m-f 09/04/23</u> <u>10X</u>
			<u>m-f 09/04/23</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MIRROR ARM

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Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(10x)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-flare before installing plug as per dwg D2010

2-Install D2057 plug as per Dwg D2010

INSPECT WORK TO CURRENT STEP

INSPECT WORK TO CURRENT STEP

MF 09/04/24

6.0 QC5



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/24 (x10)

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 10:15

OVEN TEMPERATURE: 300

FINISH TIME: 10:45

mf

09/04/24

(x10)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-04-30 (x10)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 220

88 09/04/01 (x10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/04 (x10)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

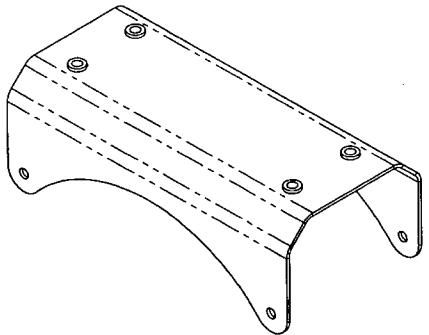
D

C

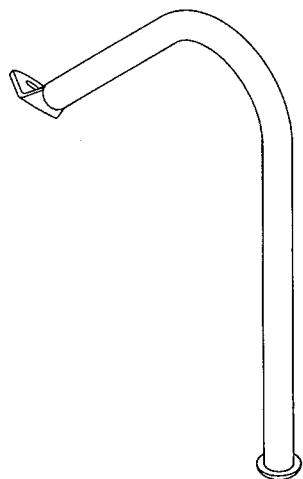
C

B

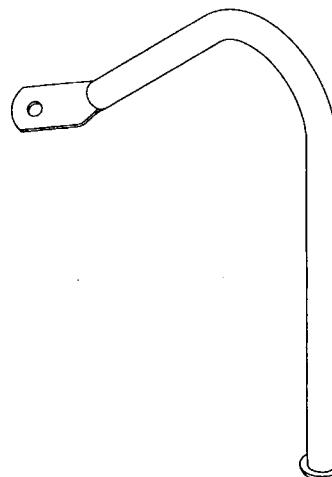
B



D2010-101 MIRROR BRACKET



D2010-103 ARM

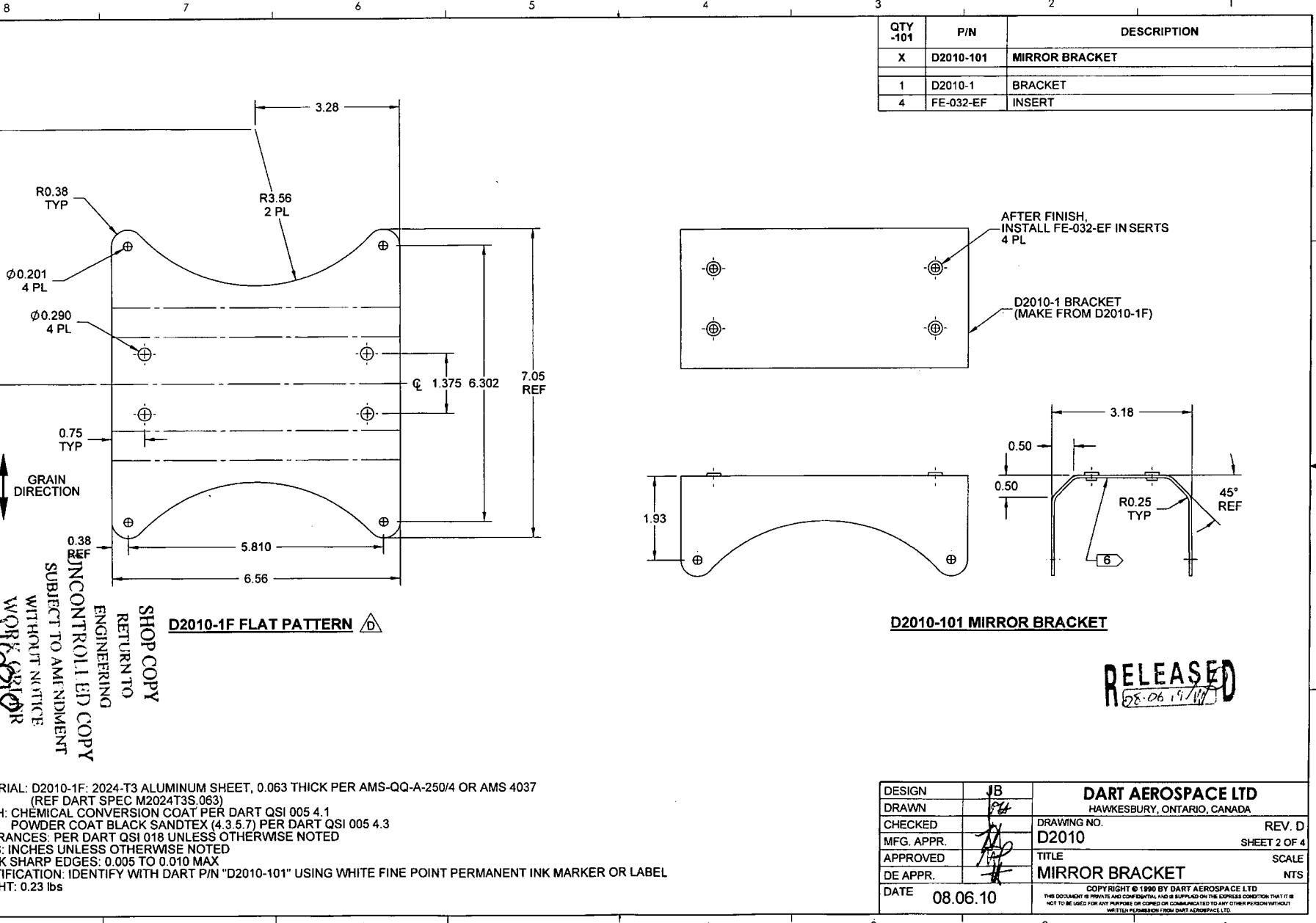


D2010-104 ARM

RELEASED
08.06.10

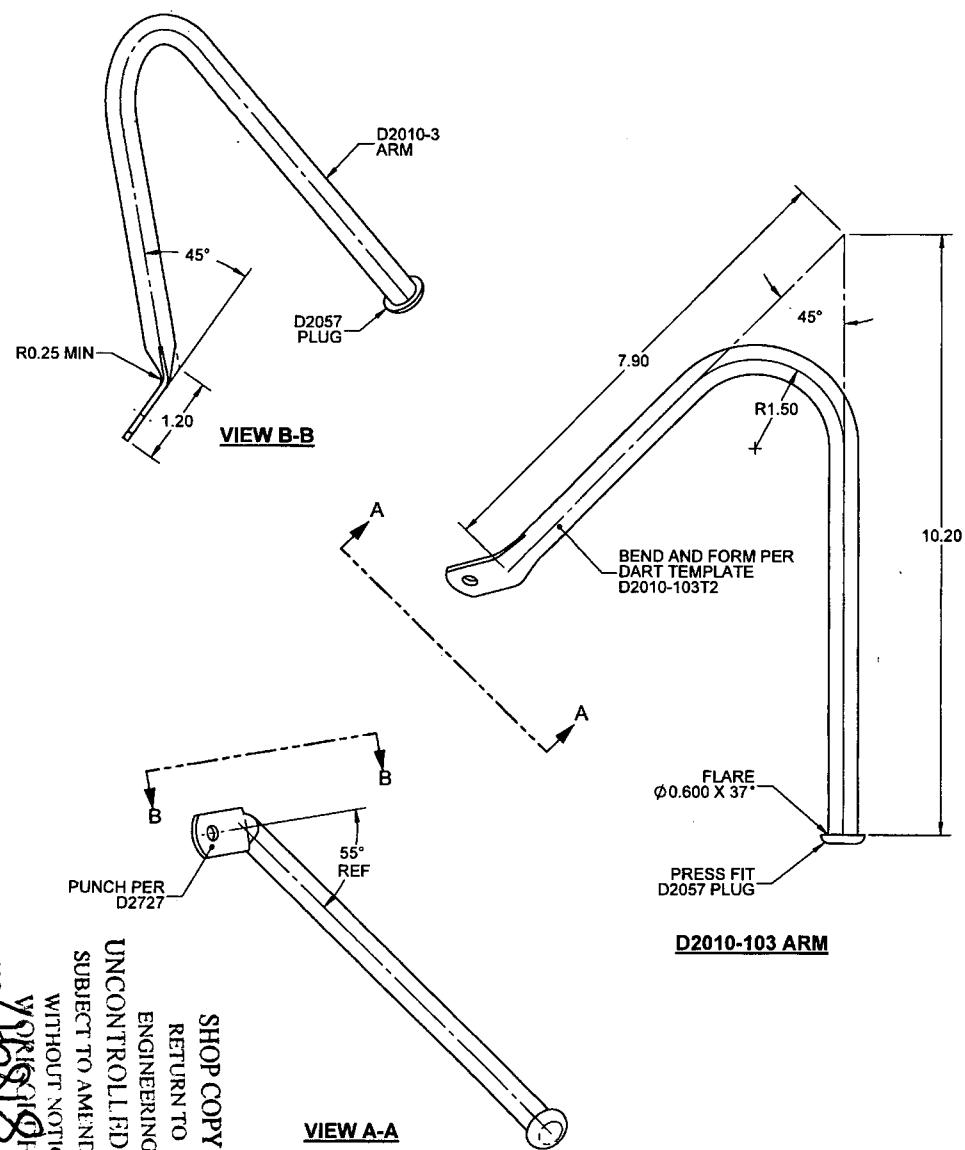
D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø 0.500 X 0.049 WALL WAS Ø 0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON: TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.80 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JB	D2010	SHEET 1 OF 4
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	MIRROR BRACKET	NTS
DATE	08.06.10	COPYRIGHT © 1990 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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8 7 6 5 4 3 2 1

QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



NOTES:

- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	<i>b</i>	HAWKSLEY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>PH</i>	D2010	SHEET 3 OF 4
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	MIRROR BRACKET	NTS
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